

Work Order ID 66352

Friday, February 11, 2011 10:55:21 AM

PRELIMINARY ISSUE



Page 1

Item ID: D4317-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Viewing Plate

Stop



Start Date: 2/11/2011 Start Qty: 2.00

Required Date: 2/15/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4317

PA1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

B11-2-14

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-14

Work Order ID 66352

Friday, February 11, 2011 10:55:21 AM



Page 2

Item ID: D4317-1

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Item Name: Viewing Plate

Start Date: 2/11/2011 Start Qty: 2.00

Required Date: 2/15/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 - inspect to PA1

0.00

Dwg only

8/11/02/14



130



Small Fab

Small Fab

Memo
Form on roller as per dwg

0.00

0.00

SB 11/02/14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00 - inspect to PA1

0.00

Dwg. only

8/11/02/14



Work Order ID 66352

Friday, February 11, 2011 10:55:21 AM



Page 3

Item ID: D4317-1
Revision ID: PRELIM
Item Name: Viewing Plate

Accept



Setup Start



Stop



Start Date: 2/11/2011 Start Qty: 2.00
Required Date: 2/15/2011 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

#66352

MF

11-02-15

POSITIVE RECALL

EFFECTIVE 11-02-11 AUTH MF

RELEASED _____ DATE _____

Picklist Print

Friday, February 11, 2011 10:55:18 AM

Page 1

Work Order ID: 66352

Parent Item: D4317-1

Parent Item Name: Viewing Plate



Start Date: 2/11/2011

Required Date: 2/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.02.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304SI6GA		Purchased	No			100	sf	128.3800	0.3918	0.824842			



304/316 Sheet .063



PB 11-2-14

Location

Loc Qty

Loc Code

MAT

128.38

111323

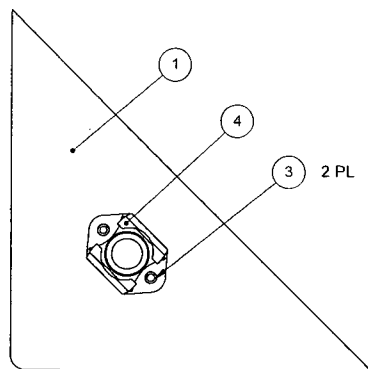
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116623

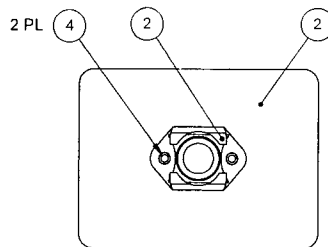
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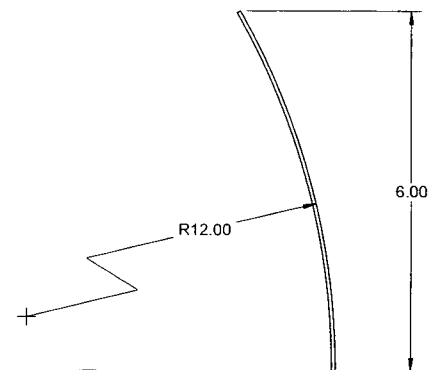
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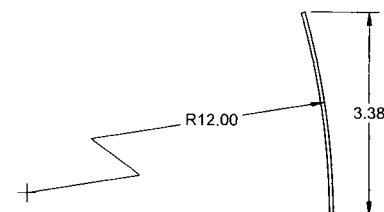
D4317-011 COVER PANEL RETAINER



D4317-013 COVER PANEL RETAINER



D4317-1 VIEWING PLATE



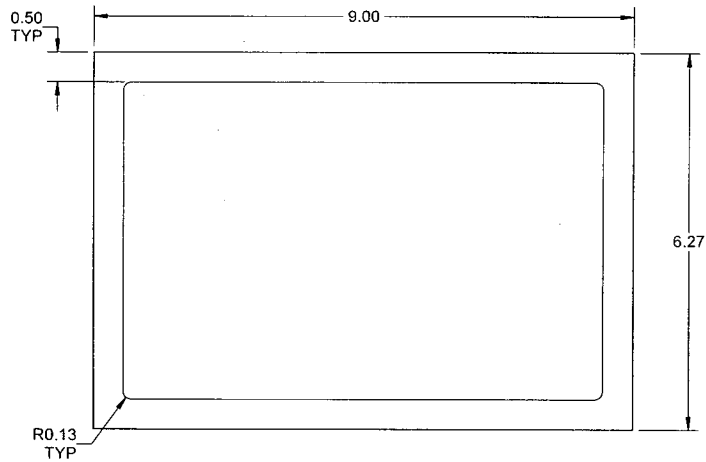
D4317-3 WIRING PLATE

NOTES:

- 1) MATERIAL -1: MAKE FROM D4317-1F
-3: MAKE FROM D4317-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4317-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT-011: 0.1 lbs
-013: 0.06 lbs
-1 & -3: SEE FLAT PATTERN WEIGHTS

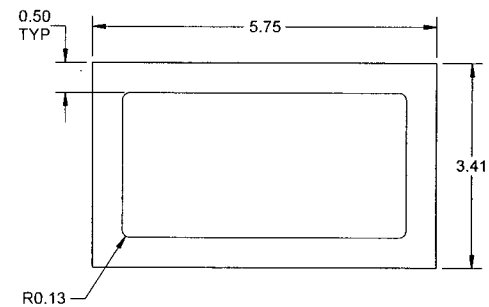
PRELIMINARY A1
11.02.01 (AJS)

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DRAWN	AJS	
CHECKED		DRAWING NO. D4317 REV. A
MFG. APPR.		SHEET 2 OF 4
APPROVED		TITLE VIEWING PLATE SCALE NTS
DE APPR.		
DATE	11.01.25	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>



D4317-1F VIEWING PLATE

PRELIMINARY A1
11.02.01 (AJS)

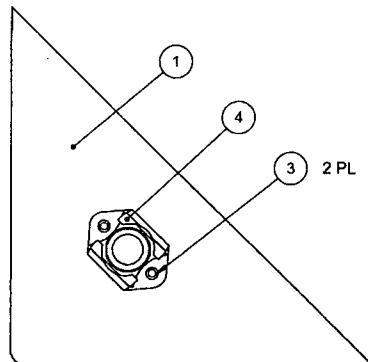


D4317-3F WIRING PLATE

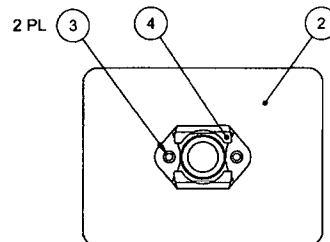
NOTES:

- 1) MATERIAL -1F, -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.060 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A24C OR ASME SA240
REF DART SPEC M304S16GA OR DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NA
- 7) WEIGHT -1: 0.26 lbs
-3: 0.14 lbs

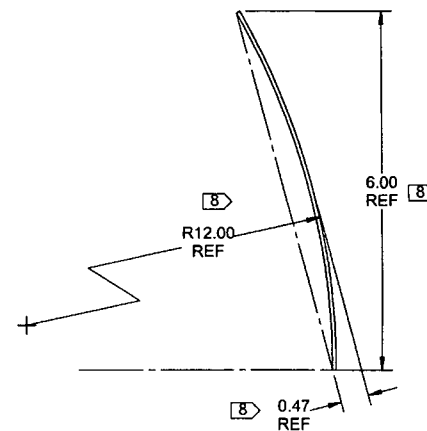
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4317	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		VIEWING PLATE	NTS
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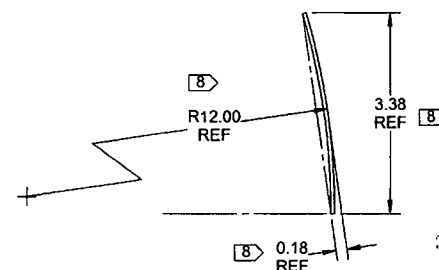
D4317-041 COVER PANEL RETAINER



D4317-043 COVER PANEL RETAINER



D4317-1 VIEWING PLATE



D4317-3 WIRING PLATE

NOTES:

- 1) MATERIAL -1: MAKE FROM D4317-1F
-3: MAKE FROM D4317-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT-041: 0.1 lbs
-043: 0.06 lbs
-1 & -3: SEE FLAT PATTERN WEIGHTS
- 8) FINAL SHAPE TO BE DETERMINED AT ASSEMBLY

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	H	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4317	SHEET 2 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	PLATE	NTS
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RELEASED
11 2011-03-03
[Signature]

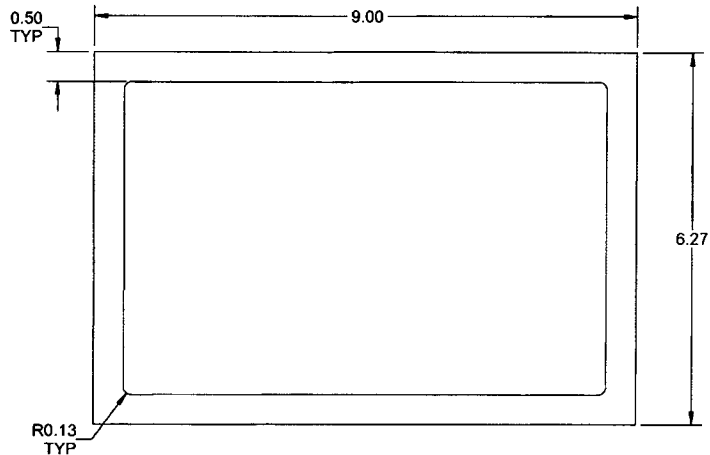
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

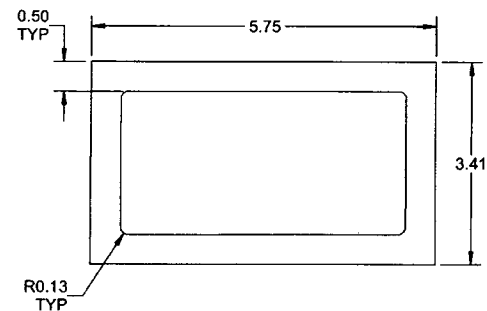
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4317-1F VIEWING PLATE



D4317-3F WIRING PLATE

NOTES:

- 1) MATERIAL -1F, -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.060 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA OR DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1F: 0.26 lbs
-3F: 0.14 lbs

RELEASED
2011-03-13

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4317	SHEET 3 OF 4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries